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POSITIVE RECALL

EFFECTIVE 20/08/10 AUTH SA

RELEASED DATE



D3144-3

Job Sheet 212120



Part No: D3144-3

Job Qty: 2 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/10/20

Job Tracking No:

Created By: Jennifer Renwick

Description: ASAP!

Due Date: 8/11/20

Type: SOLD
D3144-3 Rev. Custom

Note: DWG REV C SHEET 1 IPP Rev:A 11.03.30 now made in house DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2 pcs		8/10/20	0.17	0.25	Waterjet - Flow		20/08/10
110	QC 2	2 pcs		8/10/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/08/10
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
120	QC 8	2	8/10/20	0.00 0.00	QC 8 - 12	
	pcs				QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
140	Handfinish - 1-1 Chemical- B4B	2	8/10/20	0.00 0.11	Handfinish - 1 - 1 - B4B	
	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 -	

N/A
DAS
21
9-89

AUG 18 2020

N/A

DAS
21
9-89

AUG 18 2020

					B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 4 Black Sand - B4B	2 pcs	8/11/20	0.00 0.04	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	DAS 21 9-89 N/A
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	AUG 18 2020
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
160	QC 3	2 pcs	8/11/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	N/A
					QC 3 - 3	DAS 21 9-89
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	AUG 18 2020
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	2 pcs	8/11/20	0.00 0.00	Packaging 3 - 1 - B4B	AUG 18 2020
					Packaging 3 - 2 - B4B	DAS 21 9-89
					Packaging 3 - 3 - B4B	N/A
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	

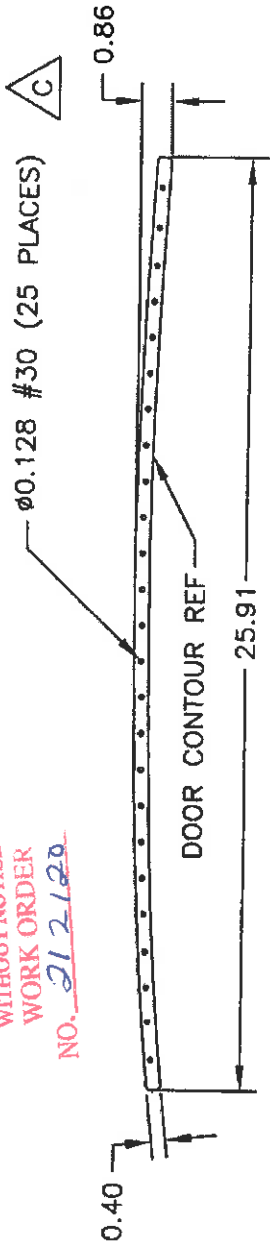
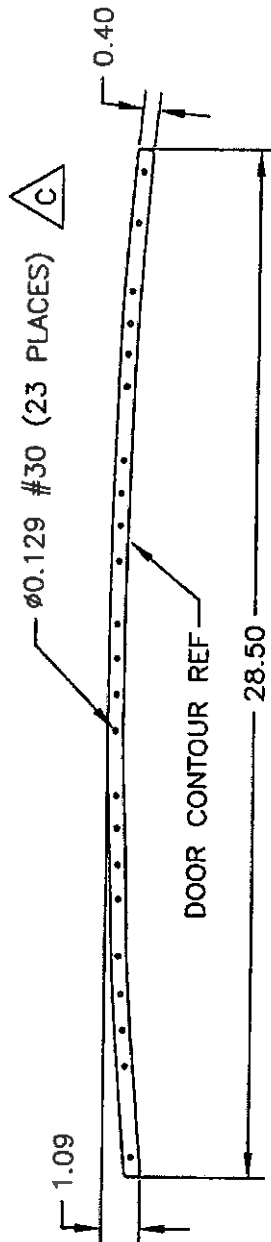
<i>Not used per SD 2008.18 5/19 20/08/18 51 9-89</i>	Packaging 3 - 13 - B4B				
	Packaging 3 - 14 - B4B				
	Packaging 3 - 15 - B4B				
	Packaging 3 - 16 - B4B				
	Packaging 3 - 17 - B4B				
	Packaging 3 - 18 - B4B				
	Packaging 3 - 19 - B4B				
	Packaging 3 - 20 - B4B				
	Packaging 3 - 21 - B4B				
	Packaging 3 - 22 - B4B				
	Packaging 3 - 23 - B4B				
	Packaging 3 - 24 - B4B				
	Packaging 3 - 25 - B4B				
	Packaging 3 - 26 - B4B				
Packaging 3 - 27 - B4B					
180 QC 21 - SA	2 pcs	8/11/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	<i>DAS 21 9-89</i>
				QC 21 - SA - 9	
				QC 21 - SA - 77	
Part Op 100 - 1-Cut as per Dwg Dwg Rev: <i>C-CUSTOM</i> Prog Rev: <i>C-CUSTOM</i> Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ Location : CA2 180 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
<i>63</i> M2024T3S.032	2024-T3 .032 Sheet	4240 sf (.212 ea)	100-Waterjet - Flow - 1	<i>S252605</i>	
<i>44</i> <i>9-89</i>	<i>20.08.10</i>	<i>.063</i>			
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.032	0	73	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.129inches + 0.005 - 0.001	0.134 0.128		Diameter
2	Doubler	0.400inches ± 0.030 <i>.450</i>	0.430 0.370	<i>P.131</i> <i>.456</i>	
3	Doubler	28.500inches ± 0.030	28.530 28.470	<i>28.50</i>	
4	Doubler	0.032inches ± 0.010 <i>.063</i>	0.042 0.022	<i>.062</i>	

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RELEASED

05.11.14

SHOP COPY
RETURN TOENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 212120**D3144-1 DOUBLER (FOR D412-694-03)**
REPLACES PREMIER P/N B30-23000-191**D3144-3 DOUBLER (FOR D412-694-01)**
REPLACES PREMIER P/N B30-23000-193**D3144-1/-3 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C1.DWG"

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3144	REV. C SHEET 1 OF 9
DATE 05.10.19		TITLE DOUBLER	SCALE 1:5
A	02.04.22	NEW ISSUE	
B	04.09.17	ADDED D3144-105/-107/-109/-111/ -115/-121/-123; MODIFY D3144-1	
C	05.10.19	ADD D3144-15; Ø0.129 WAS Ø0.098	

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Container No: S293148



Part: D3144-3

Job No: 212120

Serial No/Batch: S293148

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/10/20